

Work Order ID 56216

February 16, 2010 12:53:19 PM



Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *UMF*

Date: 10-2-16 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								
100		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020								
110		0.00							
	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021								
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

DP 10-2-18

DP 10-2-18

*h2 6-564
L2 13.0*

Solozko

Work Order ID 56216

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Page 2

Item ID: D3391-021

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Revision ID:

Item Name: Fwd Tube Assembly

Setup Start

Stop

Start Date: 2/16/10 Start Qty: 1.00

Required Date: 2/22/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine as per Folio FA590 Rev. F & Dwg D3391 Rev. H
Identify as D3391-1
2-Deburr

B.A 10/02/24

1 0

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B.A 10/02/24

1 0

150



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

Drill X1 Aft cap as per Dwg D3391 .1875" dia

B.A 10/02/24

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-021 PAR #: _____ Fault Category: Machining NCR: (Yes) No DQA: _____ Date: 1005-05
 Resolution: Accepted Disposition: USE AS IS QA: N/C Closed: _____ Date: 10/05/04

NCR: <u>56216</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.02.24	130	AFT CAP HOLE IS 0.400" FROM END INSTEAD OF 0.500". Incorrect position LC LOA.	<u>UP</u> 10.02.24 PC 451/412	Acceptable. e/D 71.5. RED TAG PART TO IDENTIFY THAT AFT CAP HOLE IS FURTHER AFT. REMAINING HOLE MUST BE LOCATED PER <u>dwg</u>	<u>H.A</u> 10/02/24 10/3/2	<u>OK</u> 10/02/24	<u>UP</u> 10.02.24 PC 451/412	<u>10-02-24</u>

NOTE: Date & initial all entries

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Item ID: D3391-021

Revision ID:

Item Name: Fwd Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00

Required Date: 2/22/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

G.A 10/02/24

1

0

Quality Control

170

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

am 10/02/24

1

0

Quality Control

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Item ID: D3391-021
Revision ID:
Item Name: Fwd Tube Assembly

Accept



Setup Start



Stop



Start Date: 2/16/10 Start Qty: 1.00
Required Date: 2/22/10 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

Drill Per spec on Page #2

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

4/10/3/2

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/03/03

(40)

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Item ID: D3391-021

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Revision ID:

Item Name: Fwd Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00

Required Date: 2/22/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

220

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-install spacers as per dwg D3391

A/R Magnabond 6398 batch: M112417

exp. date: 11/1/30

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

M10/3/4

M12/3/3

1 M10/3/3

DD 10-3-3

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Item ID: D3391-021

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Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 10/03/04

0

Memo

0.00

PTO =>

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

12114207

0.00

=> M 10/04/28

1 0

Memo

START TIME: 7:30 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:00 AM

0.00

0

250



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> m-l 10/04/28

(12)

Memo

0.00

Dart Aerospace Ltd

W/O: 56216		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-04-22	230.1	Pressure WASH & Reallocate As Per PAR 09-043	JL	10/04/22	(21)		S w/04/22

Part No: D3391-021 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3391-021

Accept

Revision ID:

Item Name: Fwd Tube Assembly

Setup Start

Stop

Start Date: 2/16/10 Start Qty: 1.00

Required Date: 2/22/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

255



Skidtubes

Skidtubes

Skidtubes

Memo

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****

0.00

0.00

=> M-L 10/04/28

(1X)

257



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Skidtubes

FD

260



Packaging

Packaging

Identify as per dwg & Stock Location: _____

B56674

Memo

D412-742-013

0.00

0.00

=> M-L 10/04/29

(1X)

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Item ID: D3391-021

Revision ID:

Item Name: Fwd Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00

Required Date: 2/22/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Accept

Setup Start

Stop

Cust Item ID:

Customer:

10/04/30

ME
10-4-29

Picklist Print

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Page 1

4

Work Order ID: 56216

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP A 05.09.13 New issue KJ/JLM.
IPP B 06.02.10 Dwg rev.D ecn 773 EC
IPP C 06.05.02 Added inspections EC
IPP D 07.03.13 rev F dwg EC

Start Qty: 1.00

Required Qty: 1.00

D6013-047 Manufactured No 100 Each 51.0000 1.0000
Skidtube Material

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

51

23935

3

26547

48

255

Each

95.0000

4.0000

10-2-18

D3670-4-200 Manufactured No
SPACER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

95

48198

10

48269

85

255

Each

28.0000

1.0000

1 M 12/3/13

D3401-041 Manufactured No
Tow Cap Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

28

36216

1

41931

1

46029

16

50316 ✓

10

10/04/28
M-L
1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 56216



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP A 05.09.13 New issue
IPP B 06.02.10 Dwg rev.D ecn 773
IPP C 06.05.02 Added inspections
IPP D 07.03.13 rev F dwg

KJ/JLM.
EC
EC
EC

Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No

255 Each 22.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

10

51611

10

Main Warehouse

ST

12

45409

2

46495

10

D3566-13 Manufactured No

255 Each 82.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

80

53461 ✓

80

Main Warehouse

ST

2

45717

1

50265

1

1x m-h
10/04/28

1x m-h
10/04/28

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Shop Packet Print

Page 2

Picklist Print

February 16, 2010 12:53:16 PM

Page 3

Work Order ID: 56216

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly

Comments: IPP A 05.09.13 New issue
IPP B 06.02.10 Dwg rev.D ecn 773
IPP C 06.05.02 Added inspections
IPP D 07.03.13 rev F dwg

KJ/JLM:
EC
ECII
EC

Start Date: 2/16/10

Required Date: 2/22/10

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

Purchased

No

255

Each

388.0000

10.0000



washer

NAS1149C0332R

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

M114341

10x m-h
10/04/28

AN3C4A

Purchased

No

255

Each

1,213.000

10.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1213

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

344

113422

84

113644

490

113749

200

M114330

10x m-h
10/04/28

February 16, 2010 12:53:16 PM

Shop Packet Print

Page 3

Picklist Print

February 16, 2010 12:53:17 PM

Page 4

Work Order ID: 56216

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly

Comments: IPP A 05.09.13 New issue
IPP B 06.02.10 Dwg rev.D ecn 773
IPP C 06.05.02 Added inspections
IPP D 07.03.13 rev F dwg



KJ/JLM:
EC
EC
EC

Start Date: 2/16/10

Start Qty: 1.00

Required Date: 2/22/10

Required Qty: 1.00

D3672-I Manufactured No 255 Each 1,704.000 4.0000



Phenolic Washer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	1204
39275	19
42329	5
47628 ✓	180
52505	1000

Main Warehouse

ST117	500
51674	500

AELS-1032-130 Purchased No



INSERT

AELS-1032-225 Purchased No



INSERT

255 Each 0.0000 2.0000
M114407

255 Each 0.0000 10.0000
M110768

4x m-l w/04/28
2x m-l w/04/28
10x m-l w/04/28

February 16, 2010 12:53:17 PM

Shop Packet Print

Page 4

DART AEROSPACE LTD		Work Order: 56216
Description: Float Skidtube (412)		Part Number: D3391-1
Inspection Dwg: D3391	Rev: H	Page 1 of 1

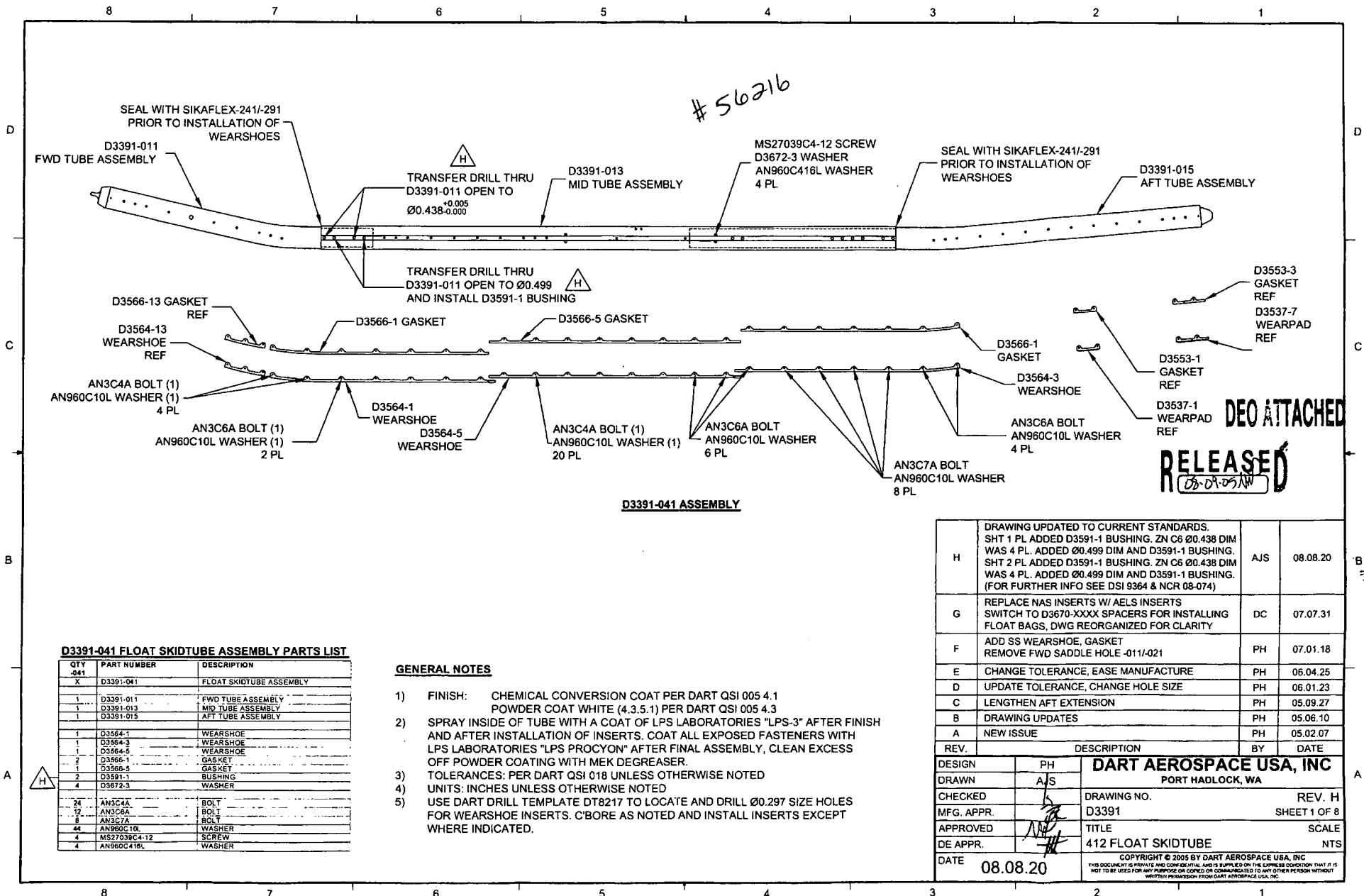
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

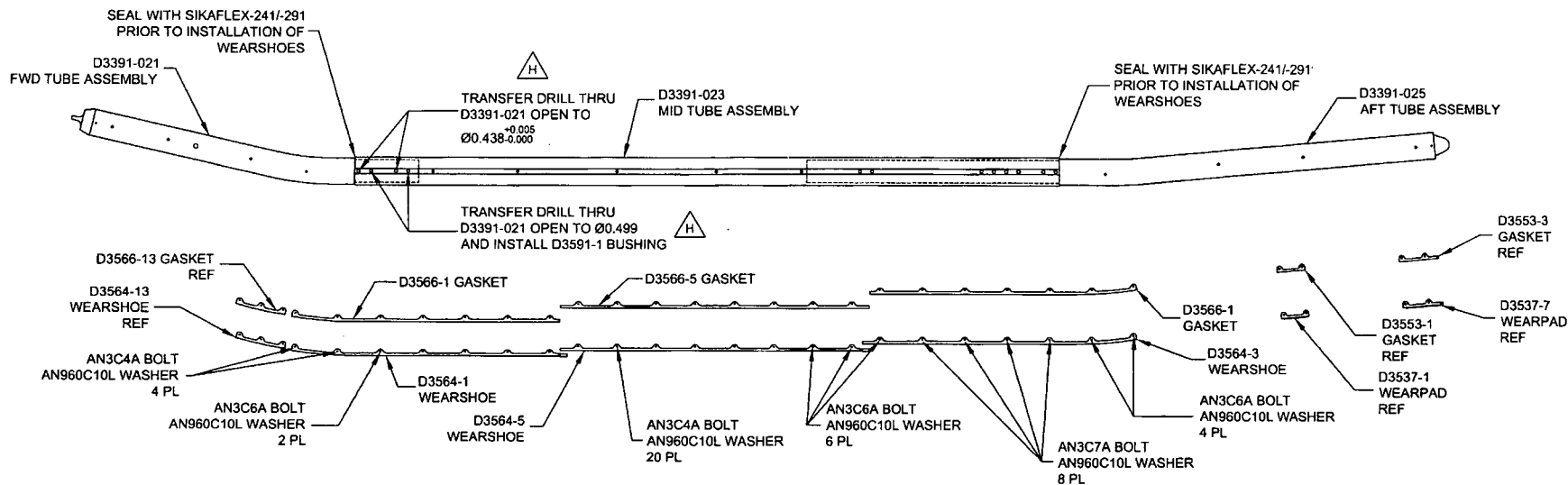
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+0.010/-0.000	0.690	✓			
3.590	+0.025/-0.010	3.612	✓			
3.300	+0.040/-0.000	3.326	✓			
1.429	+0.040/-0.060	1.403	✓			
4.250	+/-0.010	4.250	✓			
4.250	+/-0.010	4.250	✓			
0.500	+/-0.010	0.400	✓			
Ø0.1875	+0.005/-0.001	Ø0.189	✓			

Measured by: HA	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 10/02/23	Date: 10/02/23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	
E	09.12.14	Dwg Rev updated	KJ	<i>[Signature]</i>



2026



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

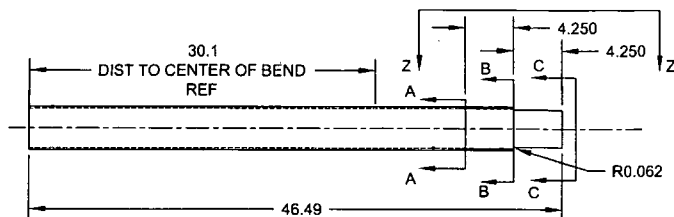
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

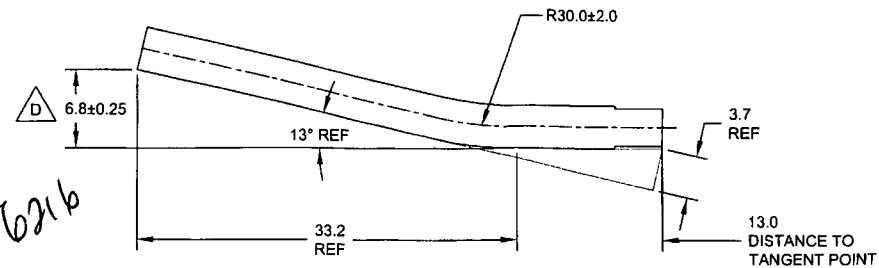
RELEASED
08-09-2020

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	N
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COMENT ON THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

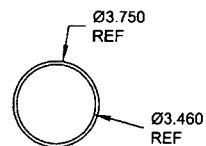


D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

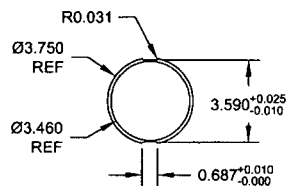
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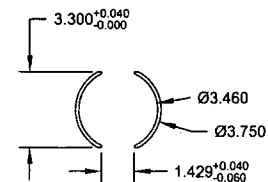
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



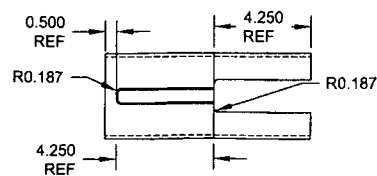
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
28-05-10

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H
MFG. APPR.			SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRELIMINARY AND LOW DENSITY. IT IS EMPLOYED ON THE EXPRESS SCOPE OF THE CONTRACT AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

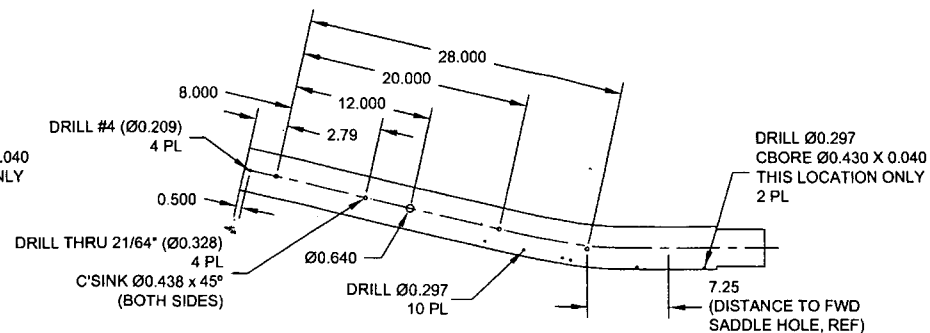
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

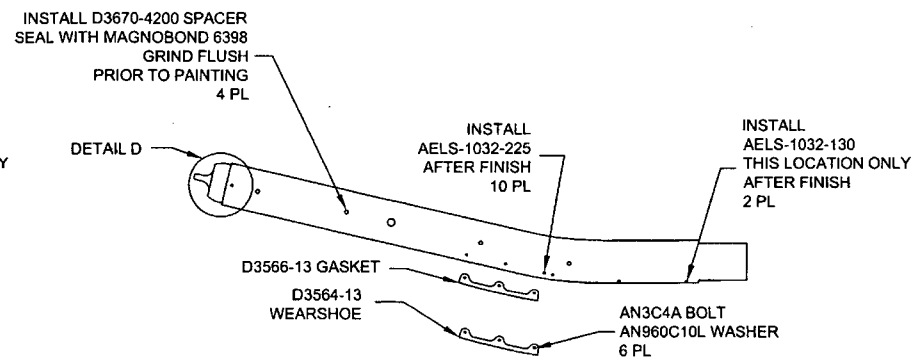
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-021 DRILLING DETAIL



D3391-021 ASSEMBLY DETAIL

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3568-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT



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02-09-25

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MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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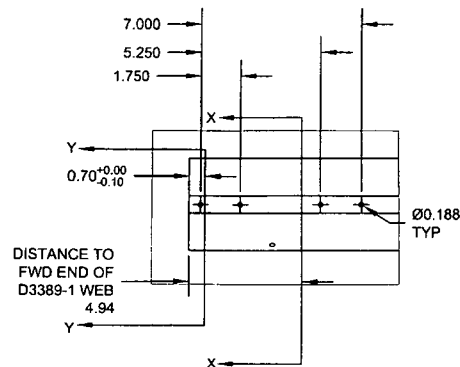
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

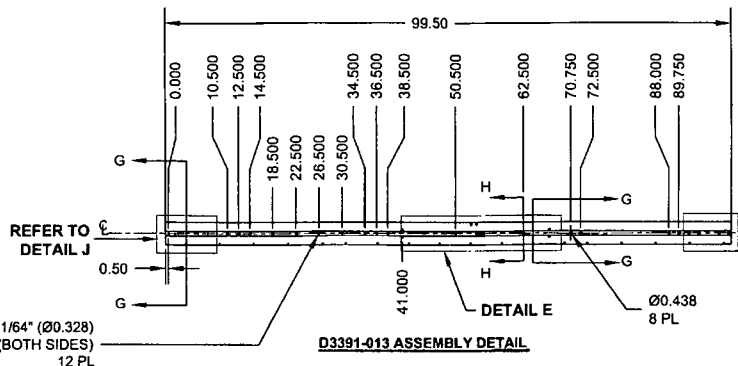
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

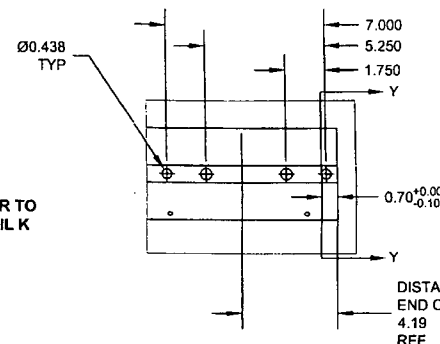


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



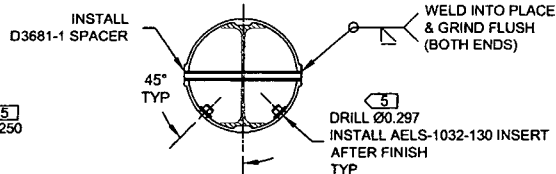
D3391-013 ASSEMBLY DETAIL
SCALE 5X



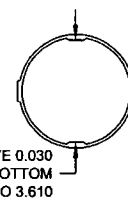
DETAIL K
SCALE 4X



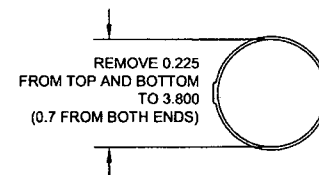
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



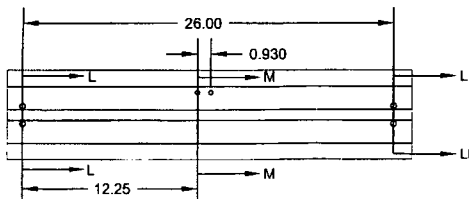
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

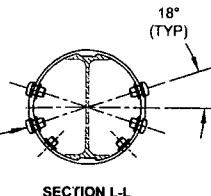
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

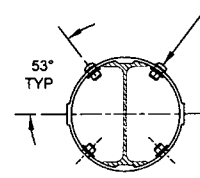


DETAIL E
SCALE NONE

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL

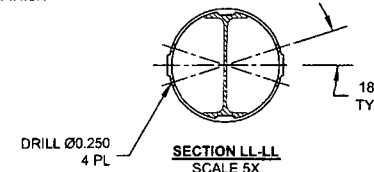


SECTION L-L
SCALE 5X



SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION LL-LL
SCALE 5X

DEO ATTACHED

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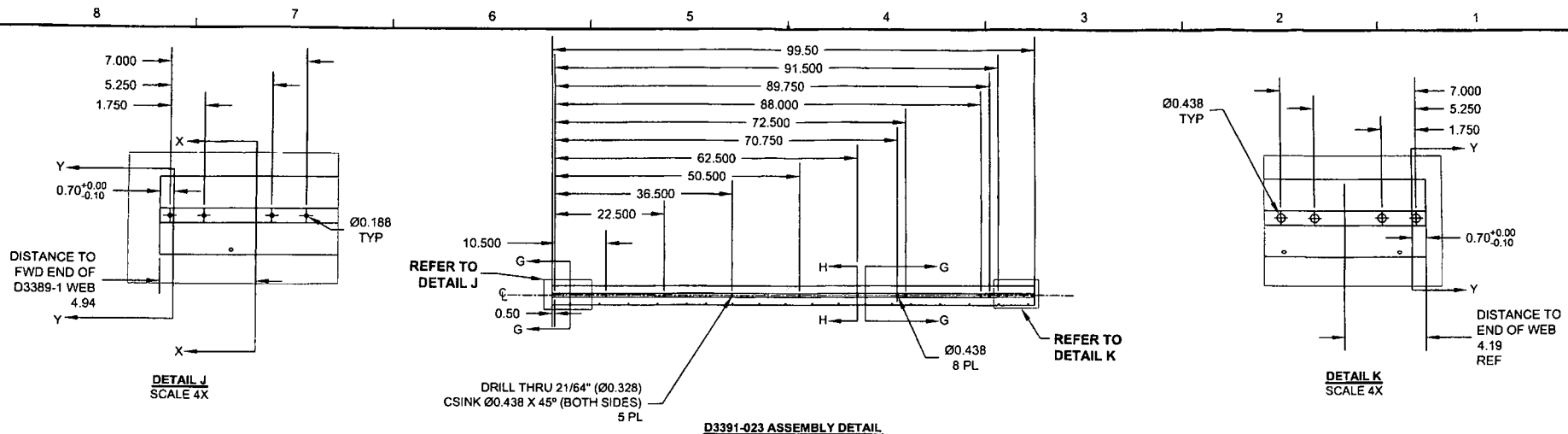
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

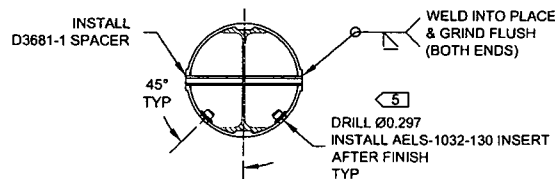
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

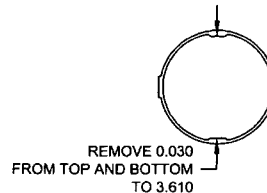
NOTE: Date & initial all entries



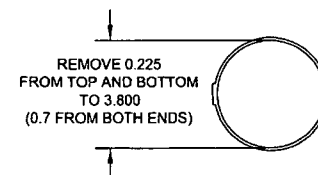
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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08-21-05

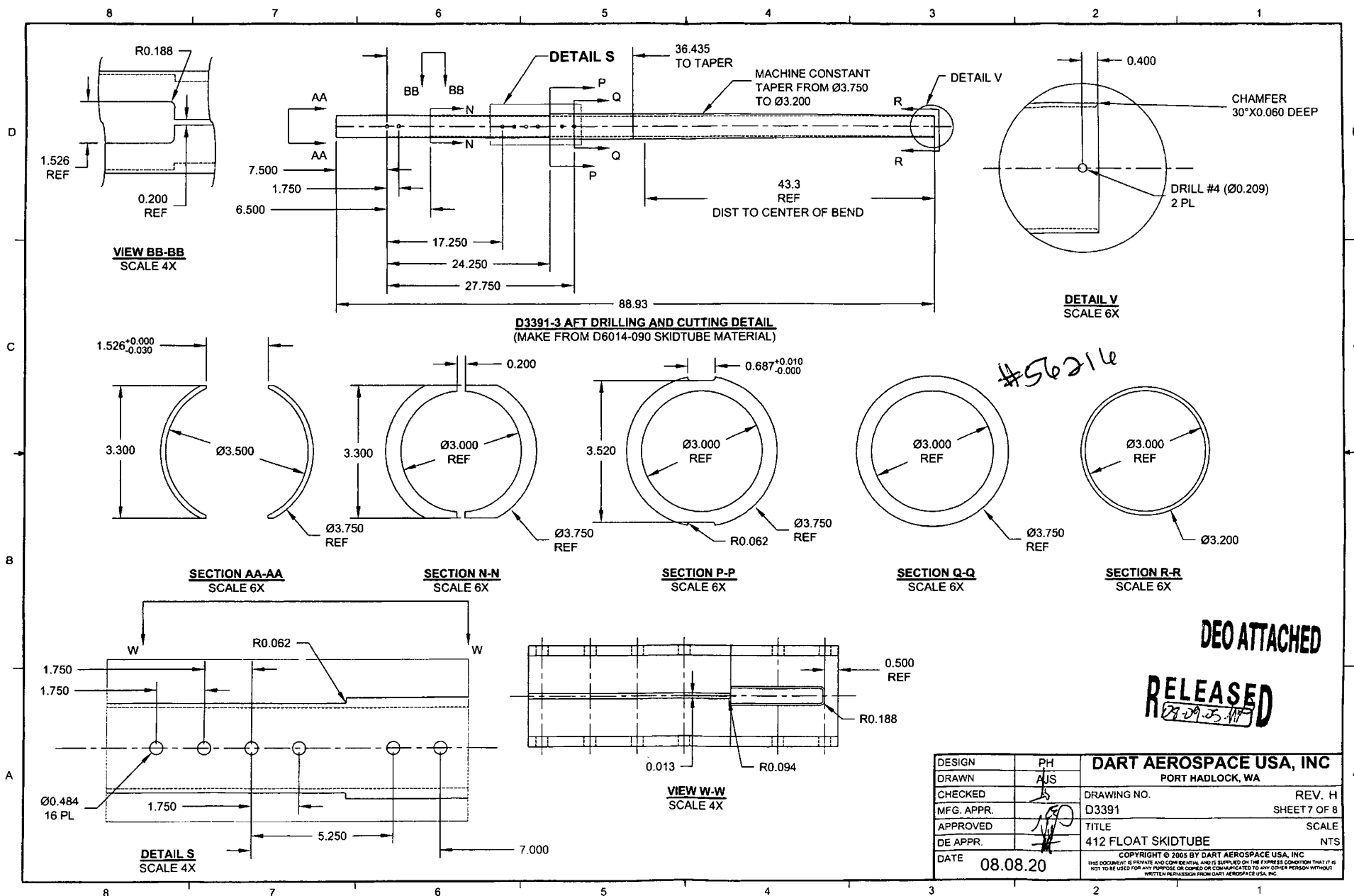
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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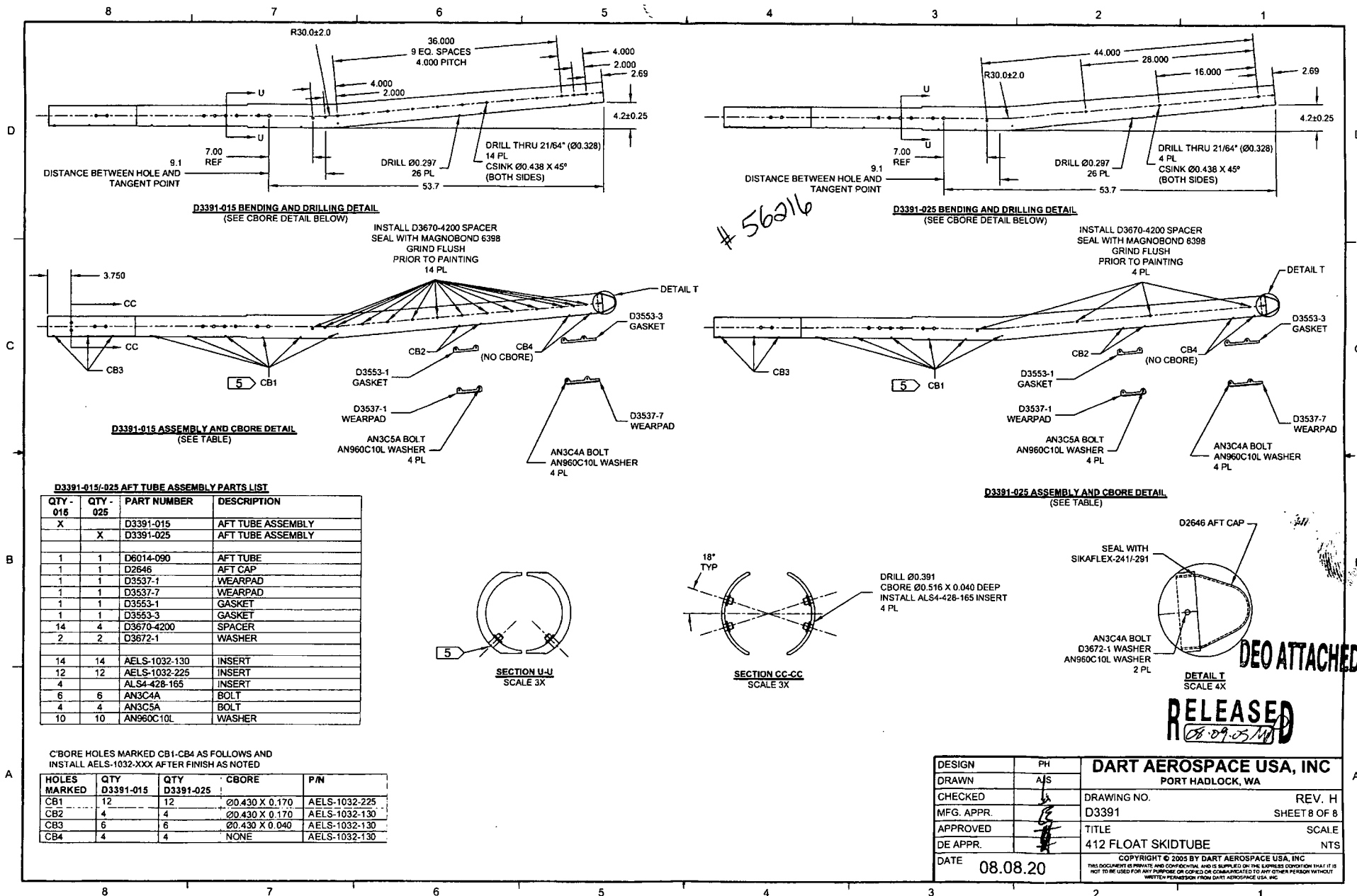
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

#56216

RELEASED
2010-02-02

MP

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